

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003197**Date Inspected:** 07-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	Tower				

Summary of Items Observed:

UT

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. This QA inspector received notification of witness inspection for non destructive testing after ZPMC personnel had completed their testing. In tower shop bay 2 this QA inspector performed Ultrasonic Testing (UT) verifications for 10 % of the complete weld lengths listed. Skin plate's final UT weld numbers ESD1-SA296 C/E 85A/B, 86A/B and 87 A/B on 45 mm to 60 mm thick plates with a total weld length of 900 mm. Upon completion of the verification it was noted at the time of this review the weldments appeared to be within compliance as per AWS D1.5. Bay 8, UT verification was performed by this QA inspector on component number ESD1-SA309 welds 9A/B and 10 A/B for CJP weldment of butt splices for the internal diaphragm rings. Welds 3A/B through 8 A/B had not been tested by ZPMC at the time of this QA inspectors review. Upon completion of the verification it was noted at the time of this review the weldments appeared to be within compliance as per AWS D1.5. A TL-6027 will be generated for these locations.

Summary of Conversations:

no conversations today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi , China- 1-376-471-0411, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
